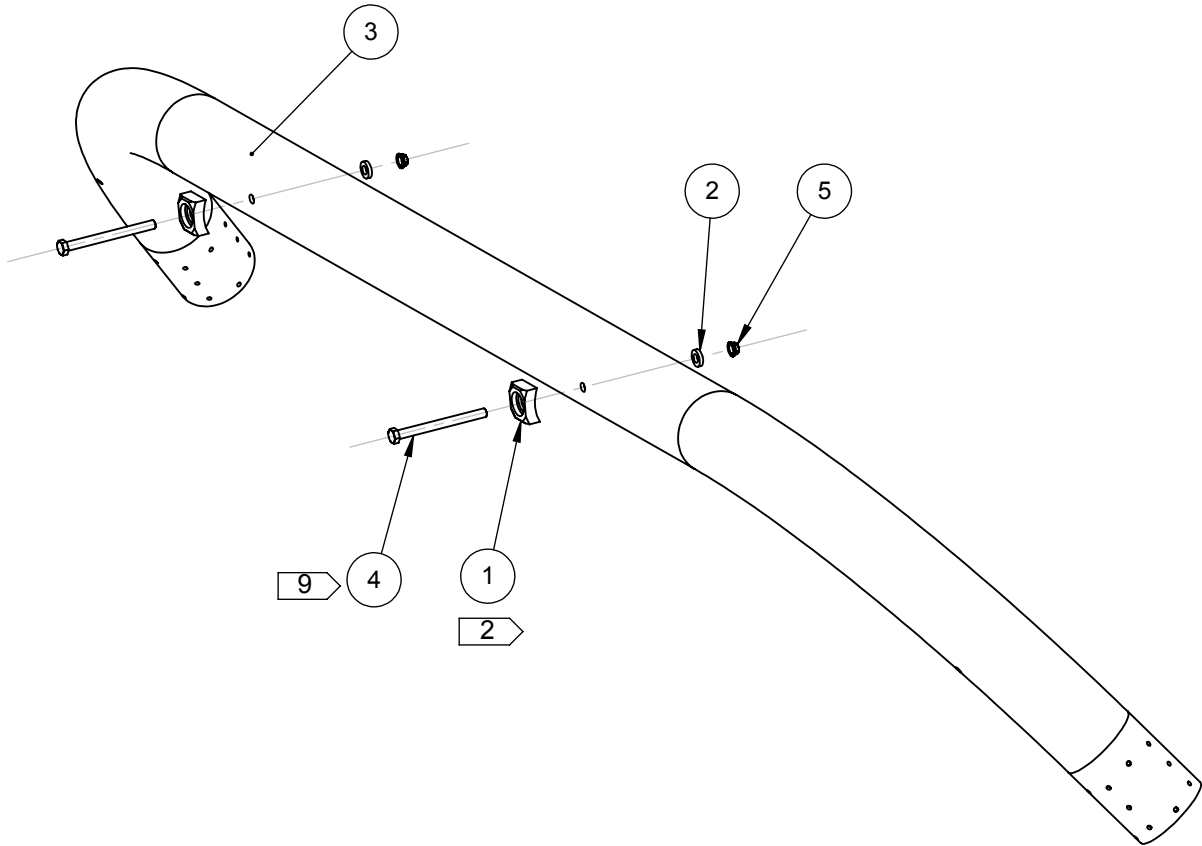
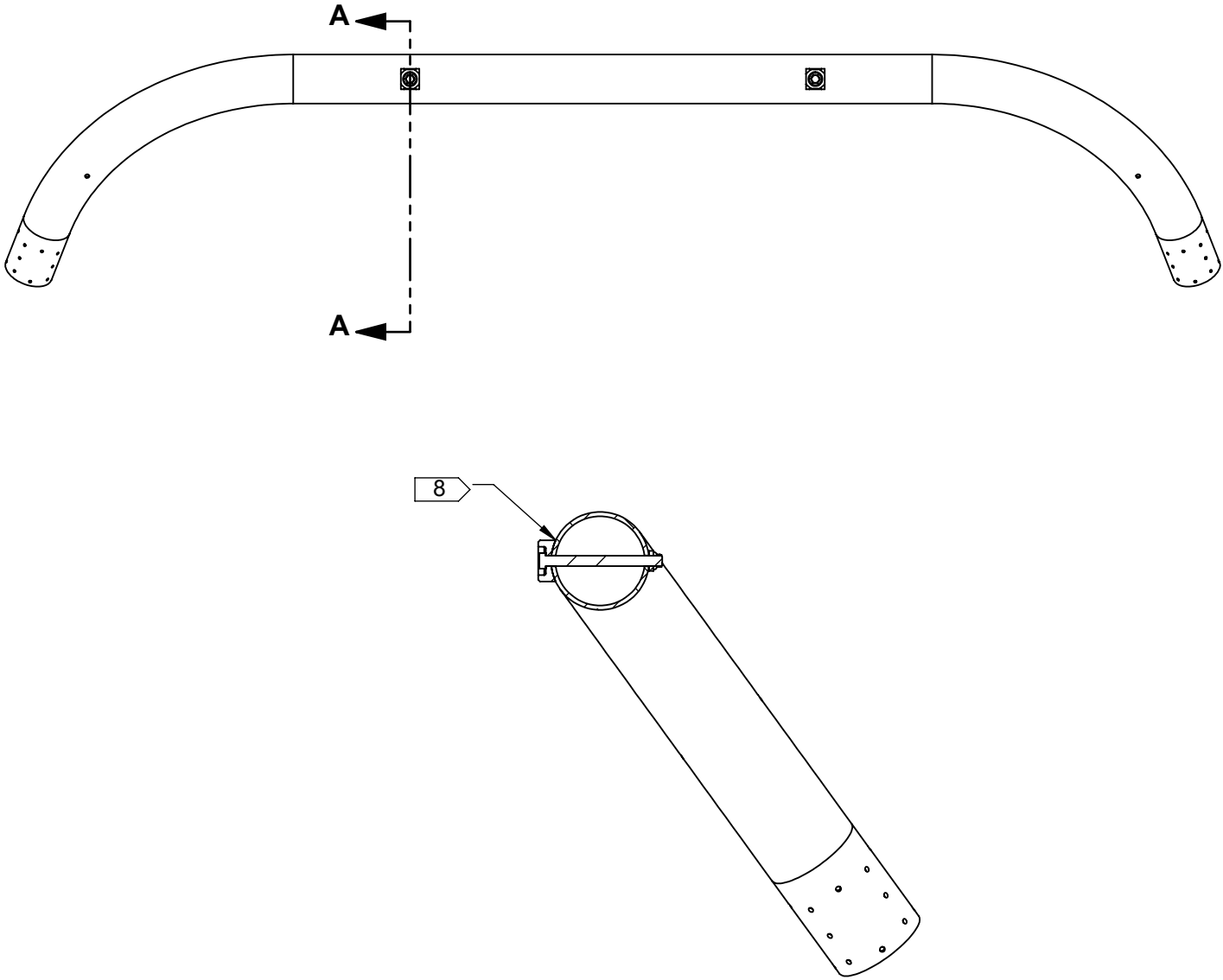


ITEM	QTY -041	P/N	DESCRIPTION
	X	D5609-041	EC130 FWD X-TUBE ASSY
1	2	D5595-1	FWD STOP BLOCK
2	2	D5595-3	WASHER, FWD STOPPER
3	1	D5609-1	EC130 FWD X-TUBE
4	2	AN6-41A	BOLT, MACHINE
5	2	MS21042L6	NUT, SELF-LOCKING



D5609-041 EC130 FWD X-TUBE ASSY

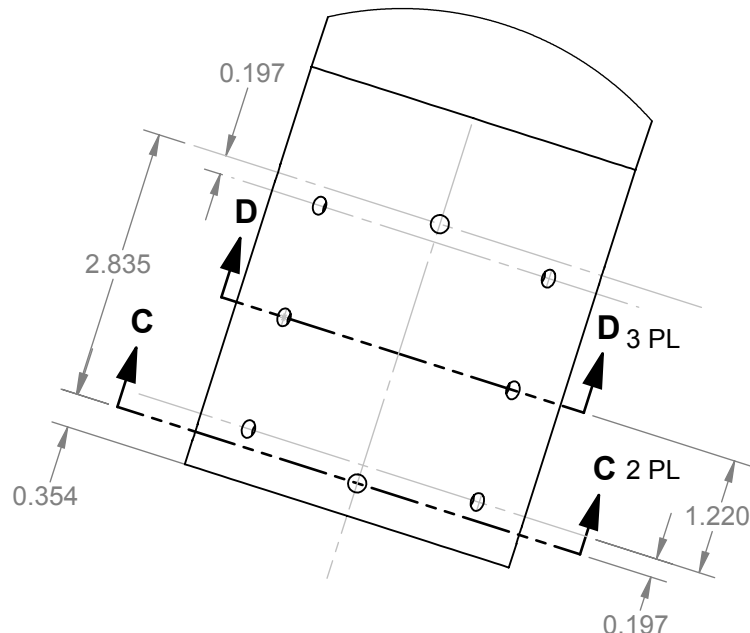
- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: PRIOR TO FINISH INSTALL THE D5595-1 STOP BLOCK USING A FILLET SEAL PER NOTE 8
IN ORDER TO MASK THIS AREA FOR ELECTRICAL CONDUCTIVITY
PRIME OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044, 6.1
 - 7) WEIGHT: 17.80 lbs
 - 8) FILLET SEAL WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT.
 - 9) INSTALL FASTENERS HAND TIGHT ONLY



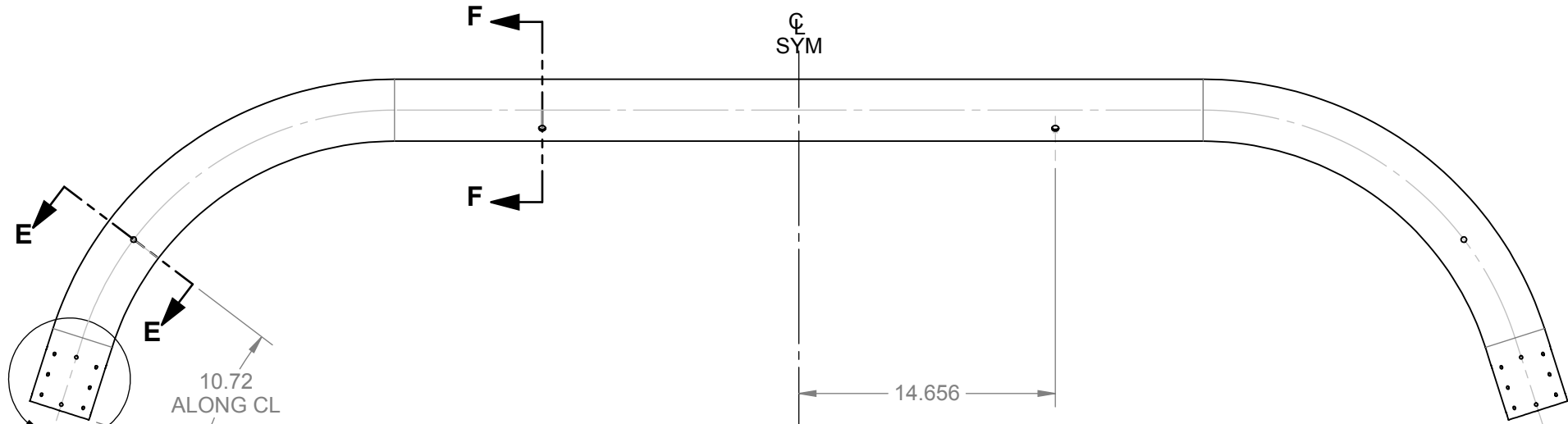
SECTION A-A
SCALE 2X

PRELIMINARY ISSUE

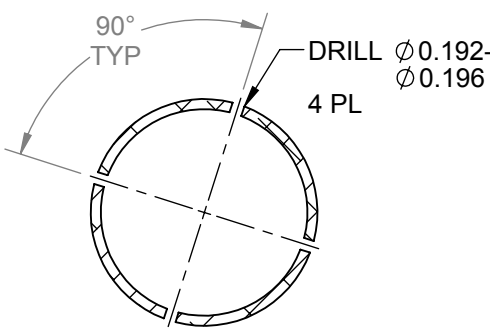
A	NEW ISSUE	NO	17.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	NO	DRAWING NO.	REV. A4
MFG. APPR.	NO	D5609	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EC130 FWD X-TUBE	NTS
DATE	17.10.31	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



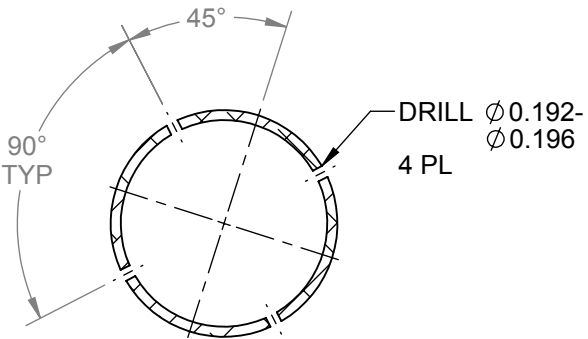
DETAIL B
SCALE 5X
2 PL



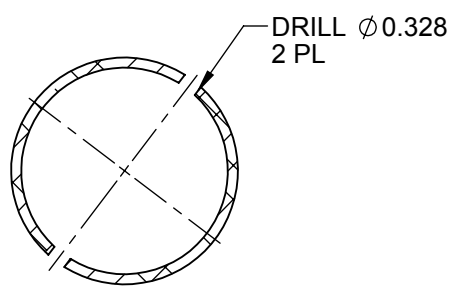
D5609-1 EC130 FWD X-TUBE



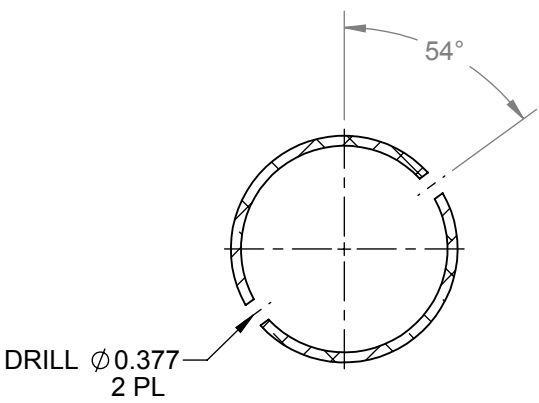
SECTION C-C
SCALE 0.75X
2 PL



SECTION D-D
SCALE 0.75X
3 PL



SECTION E-E
SCALE 3X

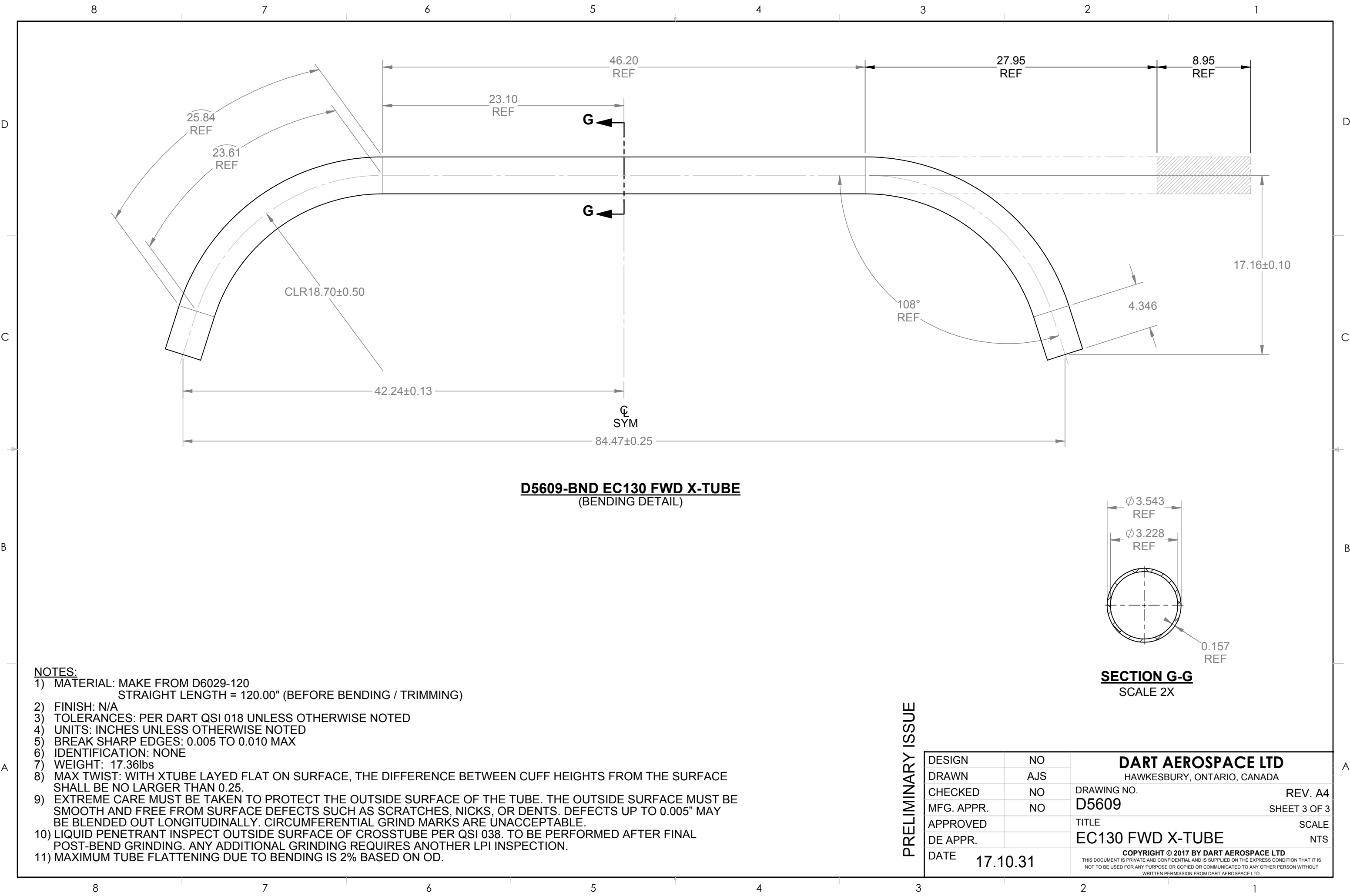


SECTION F-F
SCALE 3X

NOTES:
1) MATERIAL: MAKE FROM D5609-BND
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 17.36lbs
8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

PRELIMINARY ISSUE

DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	NO	DRAWING NO.	REV. A4
MFG. APPR.	NO	D5609	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EC130 FWD X-TUBE	NTS
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- NOTES:**
- 1) MATERIAL: MAKE FROM D6029-120
STRAIGHT LENGTH = 120.00" (BEFORE BENDING / TRIMMING)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 17.36lbs
 - 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
 - 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
 - 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.
 - 11) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.

PRELIMINARY ISSUE

DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	NO	DRAWING NO.	REV. A4
MFG. APPR.	NO	D5609	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EC130 FWD X-TUBE	NTS
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